

ASP

Work Order ID 122214

July-10-14 1:18:20 PM

122214

Page 1

Item ID: D4970-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Windshield Deflector - Lower

Start Date: 7/10/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/10/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MJS Date: 14-07-16

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4970

C

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK AT 27.625"

2 0 MH
14/07/24

110

HAAS CNC VERTICAL MACHINING #1

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB302

DWG REV: C

FOLIO REV: 44

amf 14/07/25 2 0 DAS
08
9-89
B. 14/07/26

2- deburr and break all sharp edges

Work Order ID 122214

July-10-14 1:18:20 PM

122214

Page 2

Item ID: D4970-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Windshield Deflector - Lower
Start Date: 7/10/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/10/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 08 9-8C
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							DAS 20 9-8C 14-07-27
130									
QC	Memo	0.00							
Quality Control									
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
140									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O to ATG : <u>25229</u>								
	1- Black Anodize as per Dwg D4970								
	Certification of Comformity is required								

Work Order ID 122214

122214

Page 3

July-10-14 1:18:20 PM

Item ID: D4970-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Windshield Deflector - Lower
 Start Date: 7/10/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 7/10/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>MF</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									

DAS
38
9-89

MF
14-905

Work Order ID 122214

July-10-14 1:18:20 PM

122214

Page 4

Item ID: D4970-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Windshield Deflector - Lower

Start Date: 7/10/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/10/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 14-08-12

MF 14-8-12

Picklist Print

July-10-14 1:18:23 PM

Page 1

Work Order ID: 122214

122214

Parent Item: D4970-1

D4970-1

Parent Item Name: Windshield Deflector - Lower

Start Date: 7/10/14

Required Date: 7/10/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-11-27 JLM VERIFIED BY:DD
IPP REV:B AS PER REV. B JFS 14/05/08 VERIFIED BY: DD IPP REV:C
AS PER REV. C DD 14.06.17 VERF BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B2.250X02.75 0		Purchased		No		100	f	81.5000	2.302	5			

M7075T6B2 250X02 750

**

7075-T6 BAR 2.250' X 2.750"

Location

Loc Qty

Loc Code

MAT005

81.5

m126615

81.5

4.6

MH
14/07/24

DART AEROSPACE LTD		Work Order: 122214
Description: Windshield Deflector		Part Number: D4970-1
Inspection Dwg: D4970 Rev: e		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.984	$\pm .005$	0.984	✓		Vern	GA-13
.682	$\pm .010$	0.683	✓		"	"
.69	$\pm .030$	0.684	✓		"	"
3.162	$\pm .005$	3.162	✓		"	"
22.131	$\pm .005$	22.131	✓		Dial Ind.	HAAS-4
Ø.191	$\pm .005$ $\pm .001$	Ø.191	✓		Vern	GA-13
.51	$\pm .030$.510	—		Vern	ML-06
31°	$\pm 1/2^\circ$	31°	—		C-Square	
2.350	$\pm .010$	2.346	—		Vern	ML-06
.06 X 45°	$\pm .030$ X $\pm 1/2^\circ$.06 X 45°	—		"	
.148	$\pm .010$.153	—		"	
R.10	$\pm .030$	R.125	—		R-6	
1.236	$\pm .010$	1.236	—		Vern	ML-06
.190	$\pm .010$.186	—		"	
1.080	$\pm .010$	1.080	—		Vern	ML-06
.733	$\pm .010$.731	✓		"	
20°	$\pm 1/2^\circ$	20°	—		C-Square	
1.500	$\pm .005$	1.500	—		Vern	ML-06
3.500	$\pm .005$	3.500	—		"	
27.45	$\pm .030$	27.450	—		M-tape	ML-08
26.341	$\pm .010$	26.341	—		"	
Ø.192	$\pm .005$ $\pm .001$	Ø.191	—		Vern	ML-06
2.81	$\pm .030$	2.810	—		"	

Measured by: [Signature]	Audited by: DAS 20 9-09	Preliminary Approval:
Date: 14/07/25	Date: 14-07-27	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

8

7

6

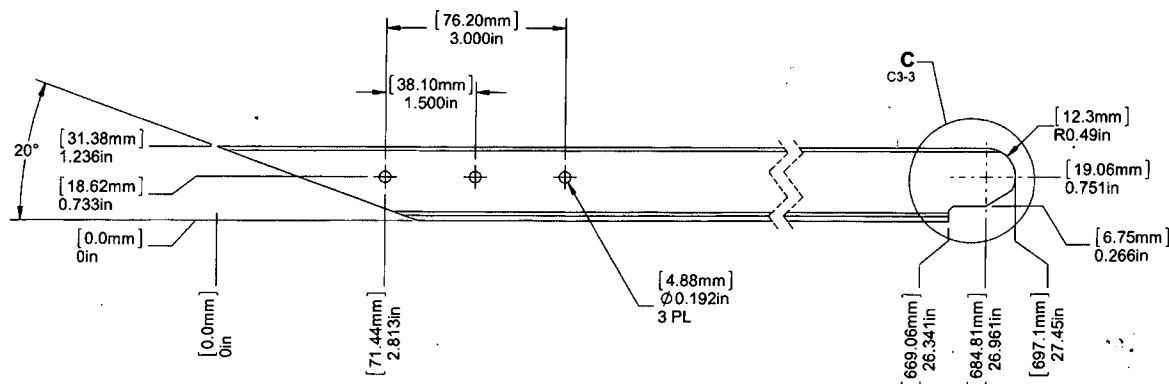
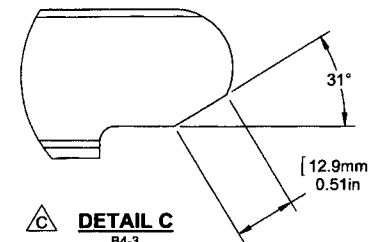
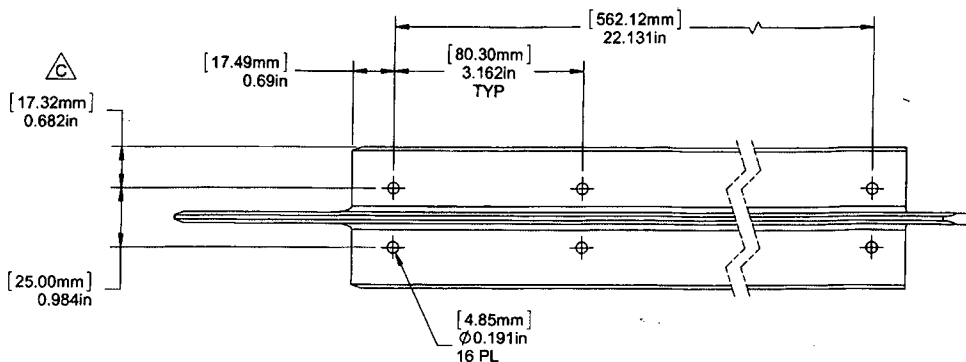
5

4

3

2

1



D4970-1 WINDSHIELD DEFLECTOR - LOWER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 122214 MLC
140710

RELEASED
2014-03-10

NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4970-1", REVISION, BATCH NUMBER AND
DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
- 7) WEIGHT: 1.34 lbs (0.62 kgs)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4970-1-C.IGES
- 9) REFERENCE APICAL PART NUMBER 647.9413

APPROVED

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4970	SHEET 3 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WINDSHIELD DEFLECTOR	NTS
DATE	14.06.05	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63190

Date: 05-Aug-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 18 PCS D4970-5 (6.15) 4 PCS D4970-1 (15.00) <i>2+2</i> HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 8 PCS D4703-043 (0.90) BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 <i>14/08/08</i> PRICE IS PER PIECE Job: 20140475 Rev:	PO: 25229 Line:	
<p align="center">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p align="center">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE: <i>5/8/14</i></p> <p>CERTIFIED SIGNATURE: <i>[Signature]</i></p> <p>RECEIVER SIGNATURE: _____</p>			